

Work Order ID 139971

December 15, 2015 4:18:37 PM

139971

*Rush
ASAP*

Page 1

Item ID: D4407-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 12/15/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/15/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SU Date: 12/15/2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4407	C

100 0.00
100
 Cold Saw Memo 0.00
 Hyd Mech Cut blanks at 58.75" 1 0 J.C.L. 12-15-16

110 0.02
110
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1-Mill as per folio FB082 & dwg D4407,
 FOLIO REV: N/A
 DWG REV: C

2-Deburr as required

EXTRA MATERIAL WILL BE CUT AT ASSEMBLY (D4406-043)

December 15, 2015 4:18:37 PM

139971

Page 2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bar

Stop *NS2*

Start Date: 12/15/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 12/15/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stam
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120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

OC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

OC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: W/AGS1

0.00

140

Packaging

Memo

0.00

Packaging

LOCATION: WA001

Work Order ID 139971

December 15, 2015 4:18:37 PM

139971

Page 3

Item ID: D4407-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bar
Start Date: 12/15/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/15/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

DEC 18 2015

Sub 20151221

Picklist Print

December 15, 2015 4:18:45 PM

Page 1

Work Order ID: 139971

139971

Parent Item: D4407-3

D4407-3

Parent Item Name: Bar

Start Date: 12/15/2015

Required Date: 12/15/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.06.06 new issue EC verified by:DD
12/02/13 new issue JFS verified by:JLM

IPP revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	654.8263	4.843	5.097895			

M304B0 250x0 500

304 BAR .250 x .500

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	40.112	
133276	27.828	
m133175	12.284	
MAT009	614.7143	
m129366	18.967	
m131748	20.949	
m132332	71.6583	
m133121	12	
m133417	210.765	
m133526	124.375	
m133596	156	

4.843 J.C.L. 15-12-16

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

D4407-1 BAR

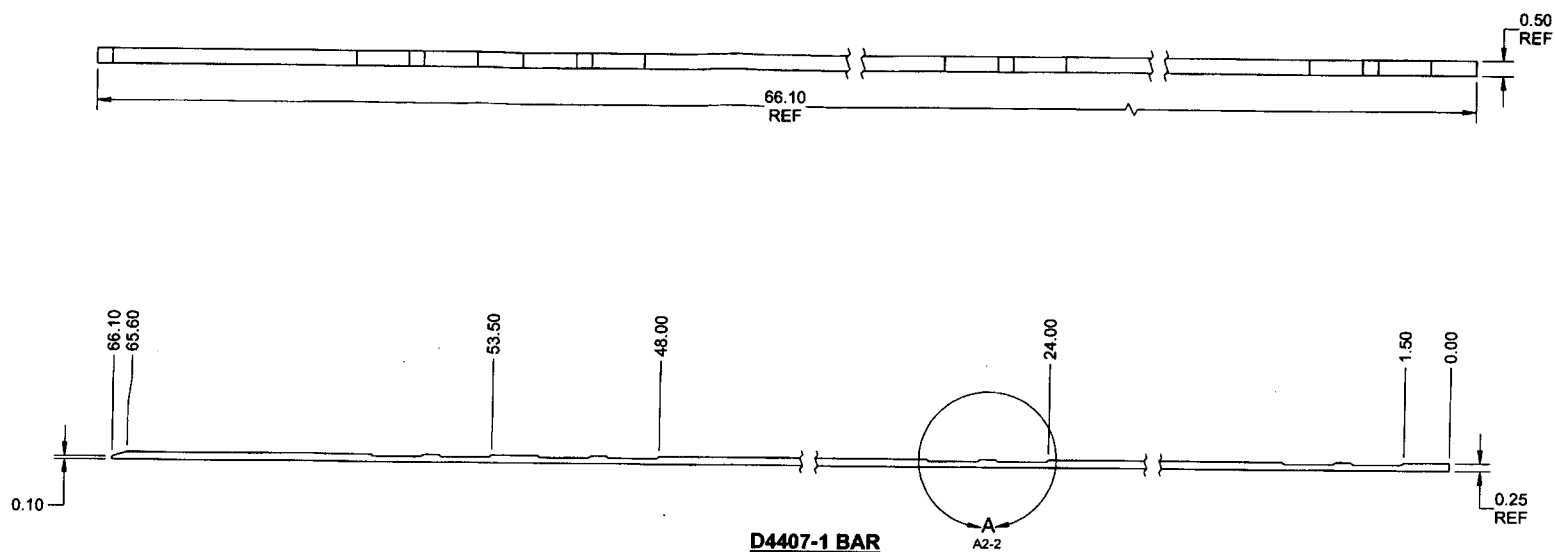
D4407-3 BAR

RELEASED
2013-03-21

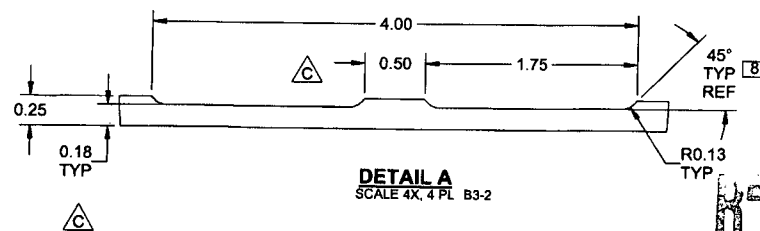
20151215 SH 139971

C	REDESIGNED WITH SHORTER CUTS. NOTE 8 ADDED. B4-2, B4-3 0.18 WAS 0.13 (REF NCR12-2031)	AJS	13.03.11
B	REMOVE TOOLING HOLES FOR -1/3; RE-DESIGN D4407-3	RF	12.01.30
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D4407	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BAR	NTS
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8 7 6 5 4 3 2 1



D4407-1 BAR



DETAIL A
SCALE 4X, 4 PL B3-2

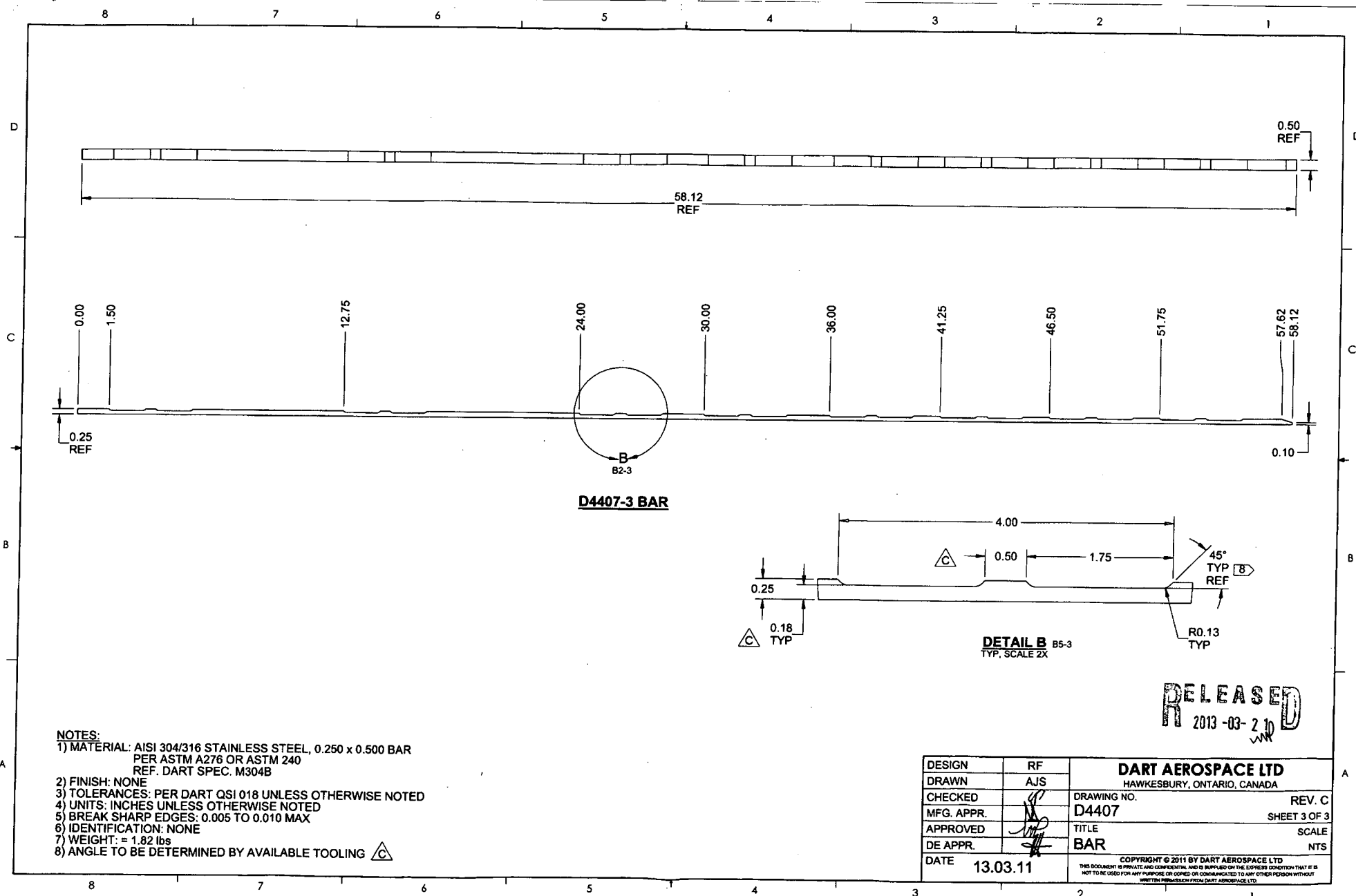
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 2.25 lbs
- 8) ANGLE TO BE DETERMINED BY AVAILABLE TOOLING



DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4407	REV. C
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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RELEASED
2013-03-21



DART AEROSPACE LTD		Work Order:	139971
Description: Bar		Part Number:	D4407-3
Inspection Dwg: D4407 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/-0.030	0.245	✓		Caliper	JCL -08
0.18	+/-0.030	0.186	✓		"	
4.00	+/-0.030	4.000	✓		"	
0.50	+/-0.030	0.500	✓		"	
1.75	+/-0.030	1.750	✓		"	
24.00	+/-0.030	24.00	✓		Tape	JCL -09
30.00	+/-0.030	30.00	✓		"	
36.00	+/-0.030	36.00	✓		"	
41.25	+/-0.030	41.25	✓		"	
46.50	+/-0.030	46.50	✓		"	
51.75	+/-0.030	51.75	✓		"	
58.12	+/-0.030	58.12	✓		"	
1.50	1/2 0.030	1.490	✓		"	
12.75	1/2 0.030	12.740	✓		"	

Measured by: J.C.L.	Audited by: DAS 20 9-89	Preliminary Approval:
Date: 15-12-16	Date: 15-12-16	Date:

Rev	Date	Change	Revised by	Approved
A	14.08.26	New Issue	KJ	